

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013795**Date Inspected:** 20-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M.Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # OUTSIDE YARD

This QA Inspector performed joint Survey Inspection along with ABF for the following Segment 9EE from Panel Point 83 to 85. Reports forwarded to team leader for further action.

Inspection details as follows

- 1)Plumpness and flatness measurements between Deck panel and deck panel diaphragm using right angle and 710mm straight edge.
- 2)Radius measurement on corner assembly cope holes
- 3)Flatness measurement on Floor beam using 1.5M straight edge.
- 4)Flatness measurement on longitudinal weld joining deck panel and corner assembly deck panel using 600mm straight edge.
- 5)Flatness measurement on longitudinal weld joining Side panel and corner assembly Side panel using 600mm straight edge.

OBG # TRIAL ASSEMBLY YARD

WELDING INSPECTION REPORT

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This QA inspector performed dimensional check along with ABF on U-Rib using 1M straight edge to check offset for below segment. Reports forwarded to team leader for further action

7CE-7DE

OBG # Bay 5

This QA inspector performed dimensional check on Traveler Rail. Reports forwarded to team leader for further action

10TR3-019

OBG # TRIAL ASSEMBLY YARD

This QA inspector witnessed final tension verification for lower chevron angle and Upper chevron left out bolts of Segment 7CE, 7DE and 7EE. Witnessed 10% on a random basis the bolts and found the tension to be in general compliance. The panel point and bolt size designations are as follows:

PP53 to PP60:

M22 X 80 – DHGM 220050 – 486 NM

M22 X 70 – DHGM 220004 – 453 NM

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
